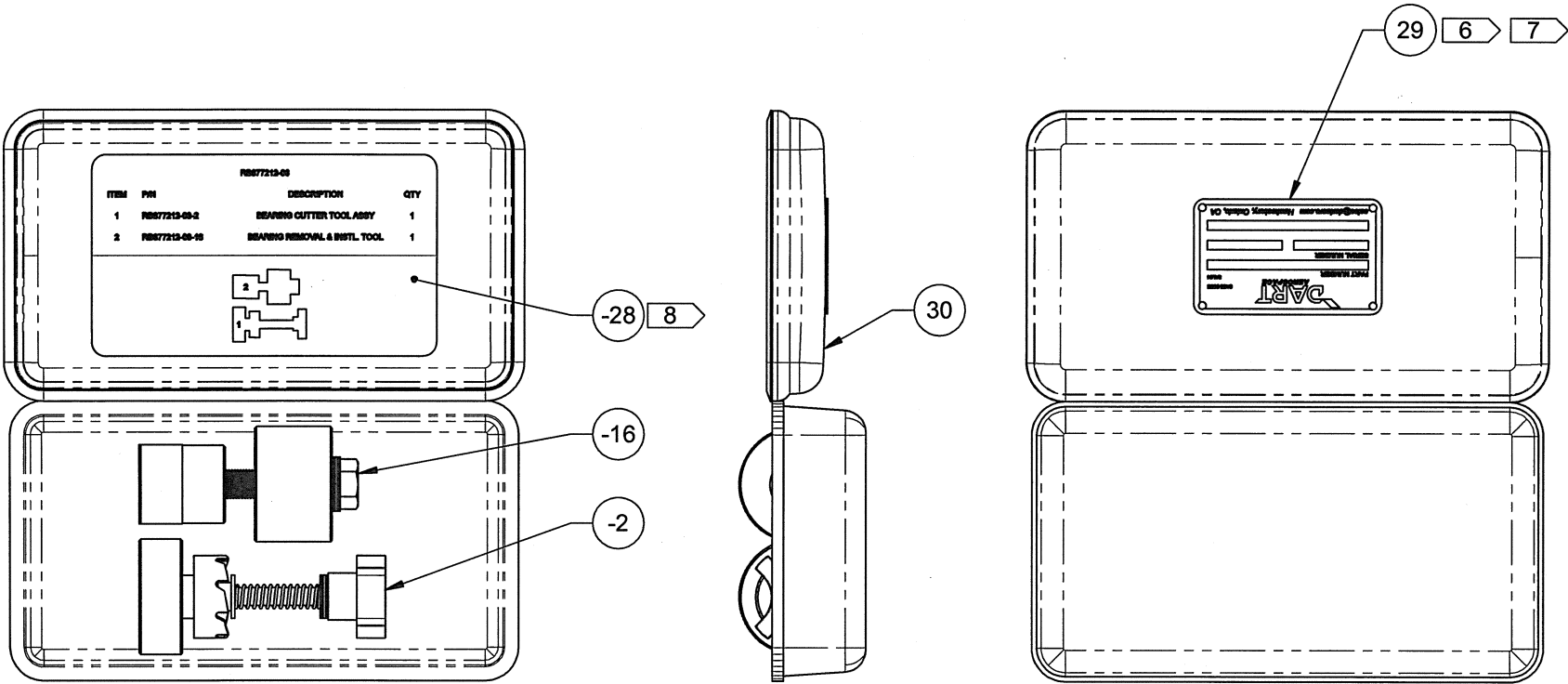




ITEM #	QTY	PART #	PART TITLE
-2	1	RB877212-08-2	BEARING CUTTER TOOL ASSY
-16	1	RB877212-08-16	BEARING REMOVAL & INSTALLATION TOOL ASSY
-28	1	RB877212-08-28	CONTENT PLACARD
29	1	RB41011	DART PLACARD
30	1	PELICAN #APP-1060-E	PELICAN CASE 1060

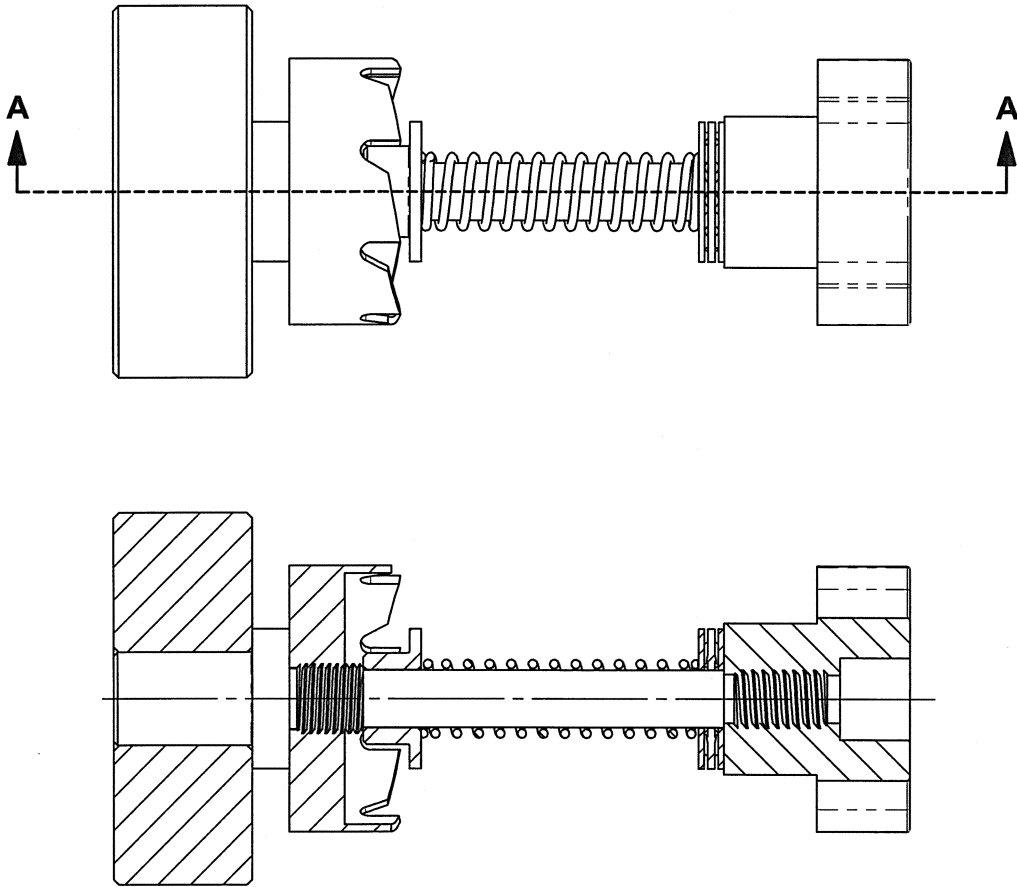


RB877212-08 TAIL ROTOR BEARING CUTTER

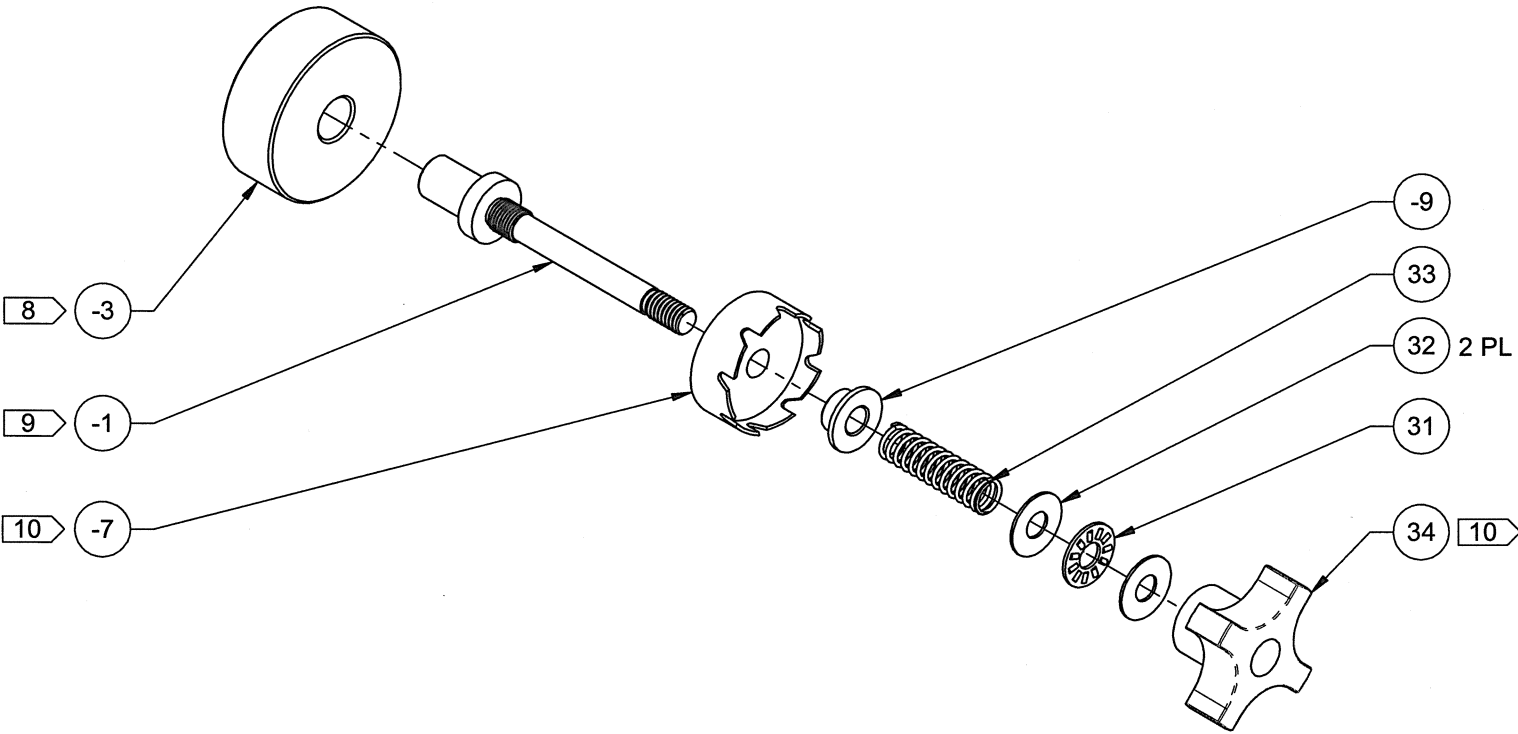
- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: ENGRAVE THE TOOL P/N ON THE DART PLACARD WHERE INDICATED
 - 7) HOT GLUE THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA
 - 8) HOT GLUE THE CONTENT PLACARD ONTO THE CASE

SEE PREVIOUS REVISION FOR MORE INFORMATION				
UPDATED DRAWING TEMPLATE				
ADDED ITEMS -28, 29 & 30				
D	-1 DIM WAS Ø0.498 TAPPER IS Ø0.5000 +0.0008/-0.0000. DIM WAS 0.750 IS 0.75. DIM WAS 3.850 IS 3.85. DIM WAS 0.400 IS 0.40. DIM WAS 0.500 IS 0.56. DIM 0.250 & 2.000 DELETED. ADDED DIM R0.008 MAX, 0.02 X 45.0° CMF & 2.90	19-652	MBB	
	-3 DIM WAS Ø0.500 IS Ø0.5000 +0.0000/-0.0008. ADDED DIM 0.03 X 45.0° CMF 4 PL. FINISH WAS BLACK ANODIZE IS RED ANODIZE. T/N ENGRAVING WAS RB877212-8 IS RB877212-08-2			
	-7 DIM WAS 1.430±0.002 IS 1.430±0.001. DIM WAS 0.38 IS 0.372. DIM WAS 0.18 IS 0.175. ADDED DIM 0.216 & R0.06. DELETED DIM 5°. DELETED NOTE MACHINE TO 1.445 +0.005/-0.003 GRIND TO SIZE AFTER HEAT TREAT. ADDED FINISH BLACK OXIDE			
	-9 DIM WAS Ø0.312 IS Ø0.313 +0.010/-0.000. ADDED DIM R0.008 MAX & 0.02 X 45.0° CMF 3 PL. MATERIAL WAS STRESSPROOF IS 4140 (28-32). FINISH WAS BLACK OXIDE IS ZINC PLATE			
	-17 DIM WAS Ø1.350 ±0.002 IS Ø1.350 ±0.001. ADDED DIM R0.008 MAX 2 PL & 0.03 X 45.0° CMF 3 PL			
	-21 DIM WAS Ø0.500 IS Ø0.510 +0.010/-0.000. ADDED DIM R0.02 & 0.03 X 45.0° CMF 3 PL. DIM WAS 1.350 IS 1.35. DIM WAS 0.850 IS 0.85. FINISH WAS BLACK ANODIZE IS RED ANOZIZE			
-27 WAS MODIFIED PART IS MACHINED PART				
REV.	DESCRIPTION		ECN #	BY
DESIGN	MBB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	MBB			
CHECKED	MBB	TOOL PART #	REV. D	
MFG. APPR.	DP	RB877212-08	SHEET 1 OF 11	
APPROVED		TITLE	SCALE	
DATE 3/21/2019		TAIL ROTOR BEARING CUTTER	NTS 	
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ITEM #	QTY	PART #	PART TITLE
-1	1	RB877212-08-1	SHAFT
-3	1	RB877212-08-3	HANDLE
-7	1	RB877212-08-7	CUTTER
-9	1	RB877212-08-9	SPRING GUIDE
31	1	NTA-512	NEEDLE ROLLER THRUST BEARING 5/16" ID. X 3/4" OD. X 5/64" WD.
32	2	TRA-512	THRUST WASHER 5/16" ID. X 3/4" OD. X 0.03" WD.
33	1	McMaster#9657K389 OR EQUIV.	ZINC PLATED MUSIC WIRE COMPRESSION SPRING 2" LG. x 0.42" OD. x 0.326" ID. CLOSE AND GROUND ENDS
34	1	Reid#DK-55 OR EQUIV.	KNOB 4-PRONG 5/16-18 UNC



SECTION A-A

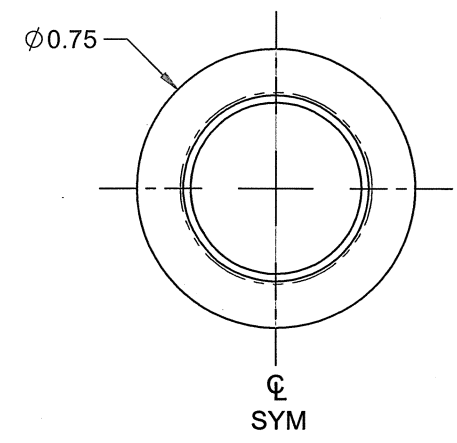
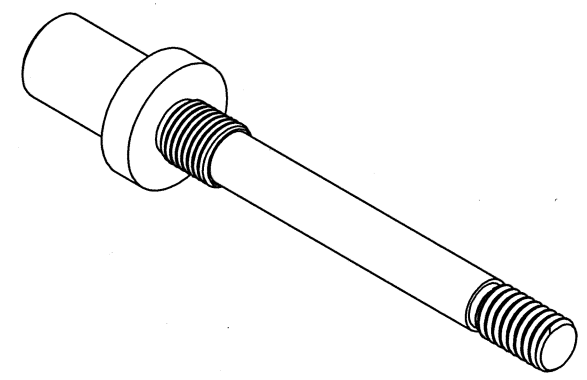


RB877212-08-2 BEARING CUTTER TOOL ASSY

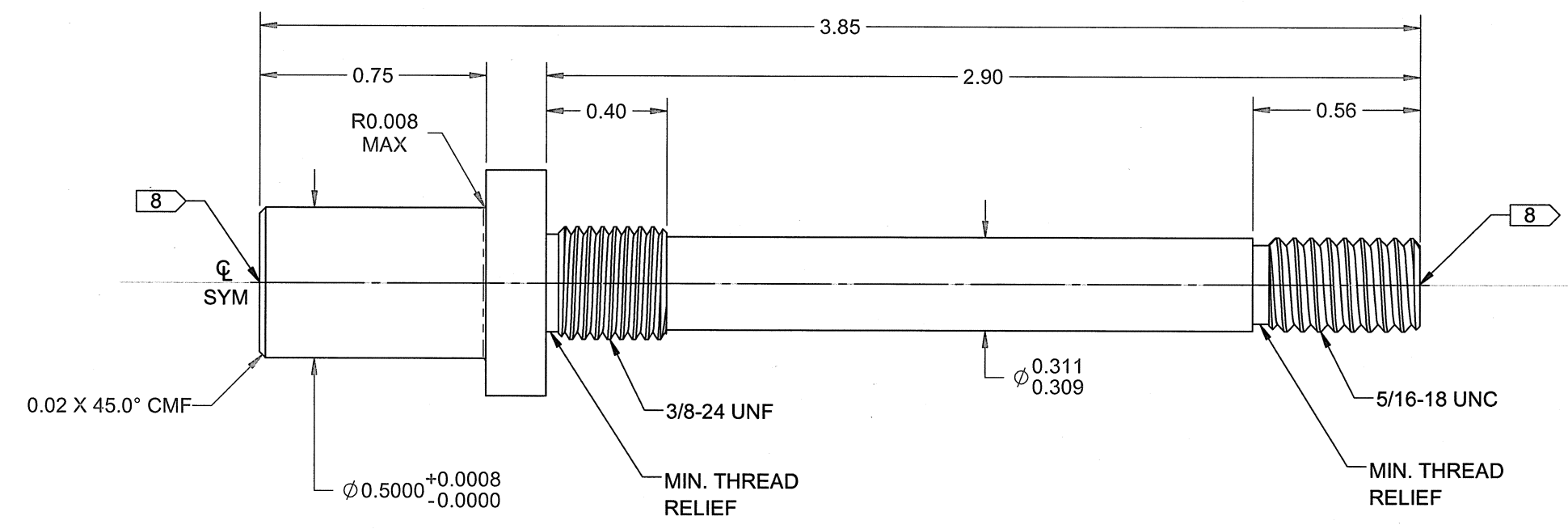
- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM -3 WITH ITEM -1, AND REMOVE EXCESS
 - 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS 3/8"-24 UNF ONLY OF ITEM -1 THEN ASSEMBLE WITH ITEM -7, AND REMOVE EXCESS
 - 10) INSTALL ITEMS -7 & 34 HAND TIGHT
 - 11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. D
MFG. APPR.	DP	RB877212-08	SHEET 2 OF 11
APPROVED	W	TITLE	SCALE
DATE	3/21/2019	TAIL ROTOR BEARING CUTTER	NTS
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8 7 6 5 4 3 2 1



RB877212-08-1 SHAFT



- NOTES:
- 1) MATERIAL: 1144 STRESSPROOF
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) CENTER DRILL IS ACCEPTABLE

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. D
MFG. APPR.	DP	RB877212-08	SHEET 3 OF 11
APPROVED	WY	TITLE	SCALE
DATE 3/21/2019		TAIL ROTOR BEARING CUTTER	NTS
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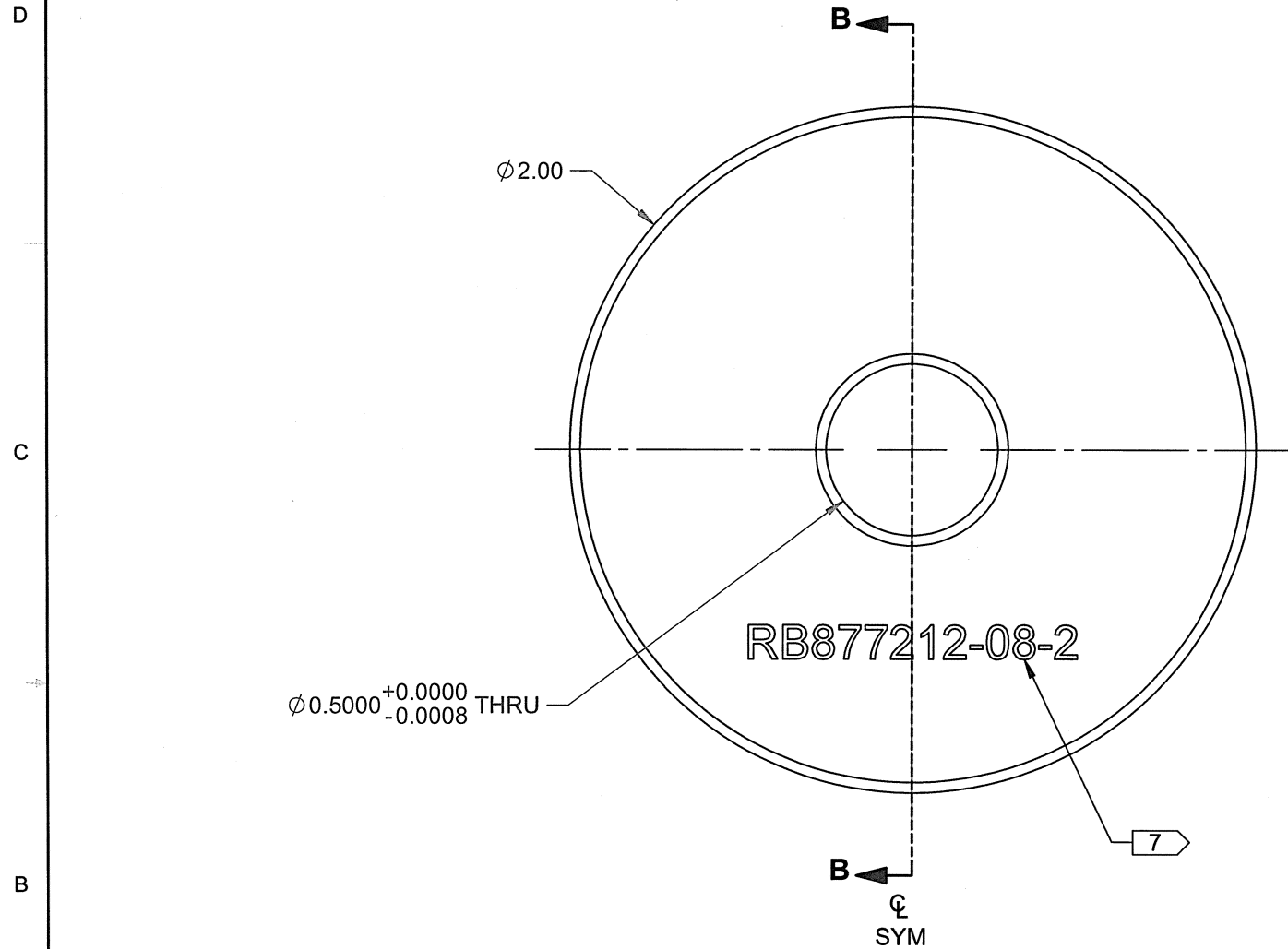
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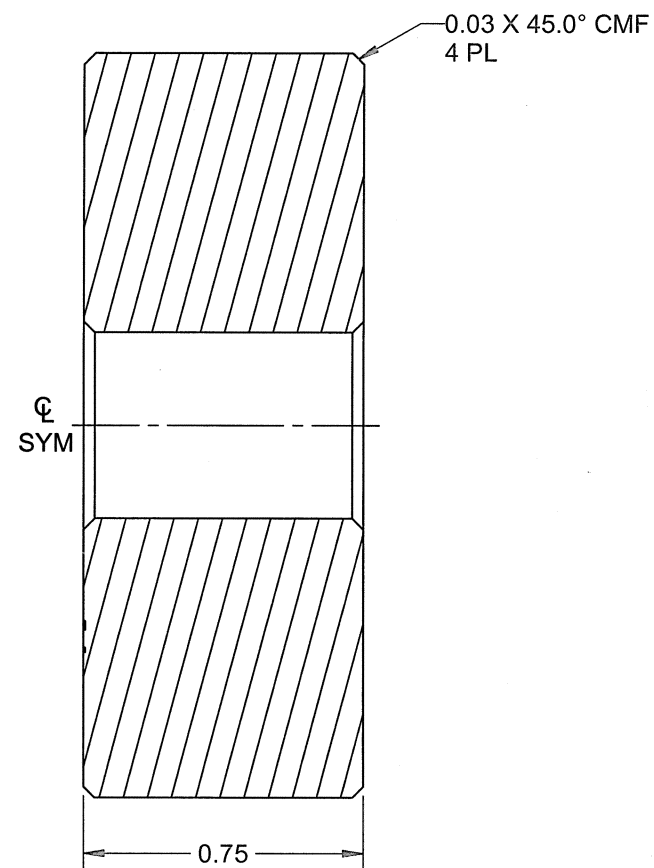
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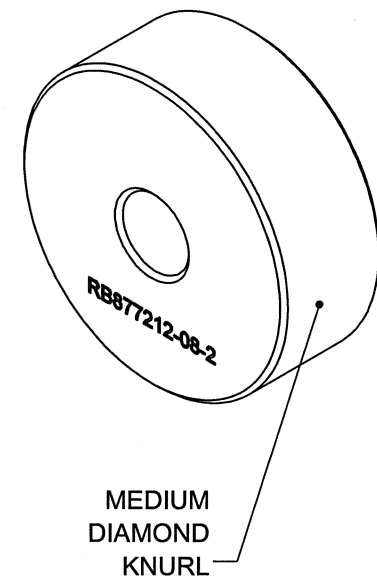
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RB877212-08-3 HANDLE



SECTION B-B



NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

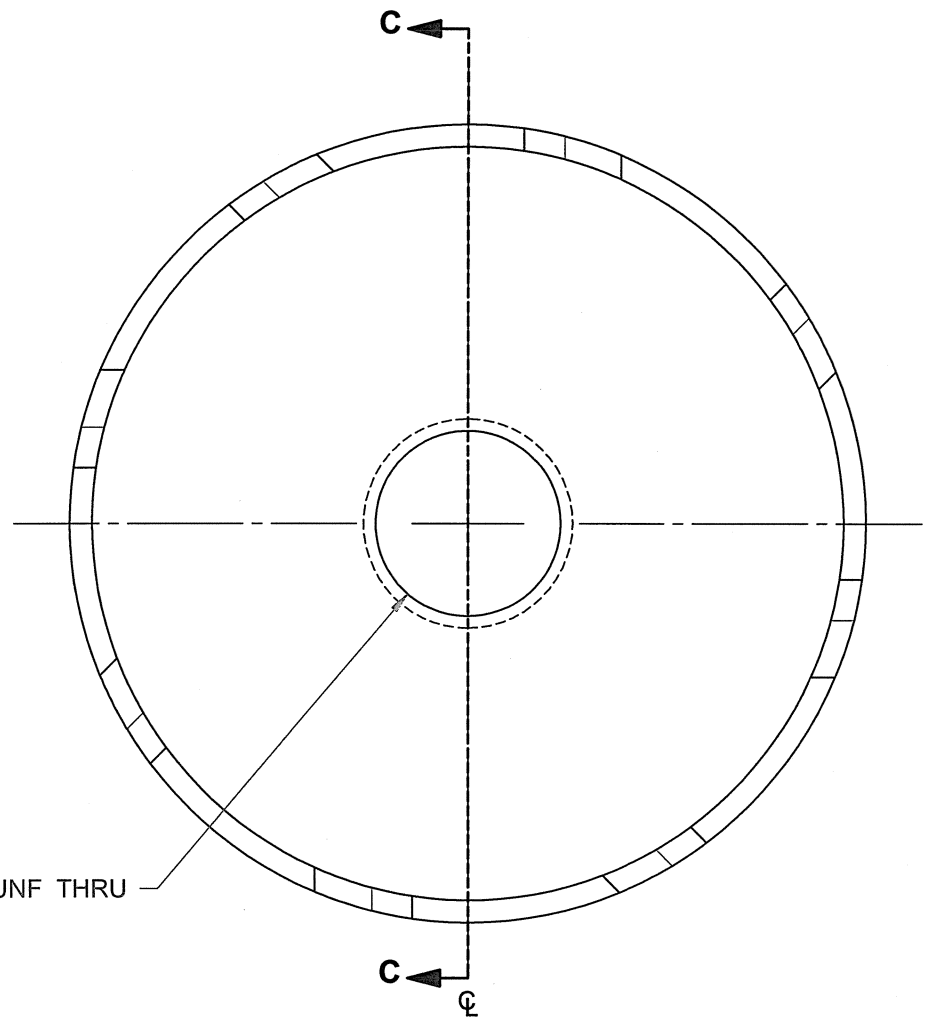
DESIGN	MBB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MBB		
CHECKED	MBB	TOOL PART #	REV. D
MFG. APPR.	DP	RB877212-08	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DATE	3/21/2019	TAIL ROTOR BEARING CUTTER	NTS
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8 7 6 5 4 3 2 1

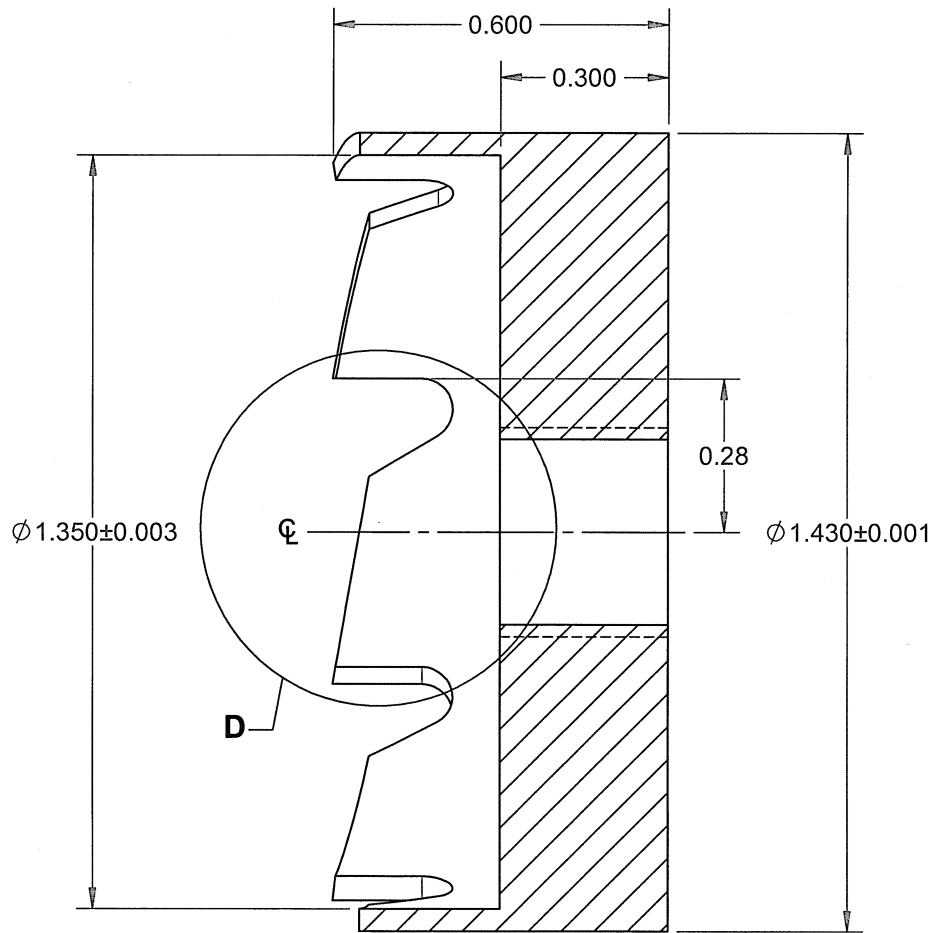
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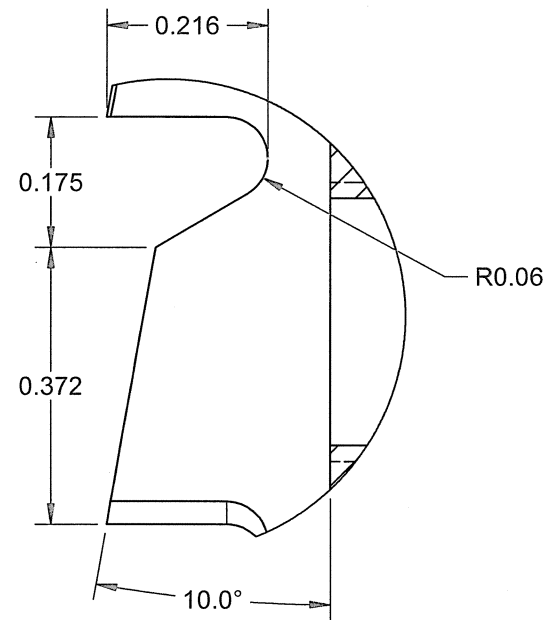
B



RB877212-08-7 CUTTER



SECTION C-C



DETAIL D
8 PL EQUALLY SPACED

NOTES:

- 1) MATERIAL: O1
- 2) HEAT TREAT: 50-60 RC
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. D
MFG. APPR.	DP	RB877212-08	SHEET 5 OF 11
APPROVED	WJ	TITLE	SCALE
		TAIL ROTOR BEARING CUTTER	NTS
DATE	3/21/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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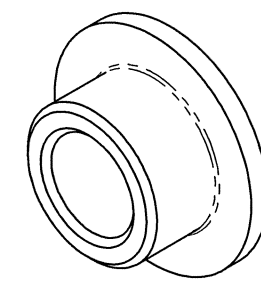
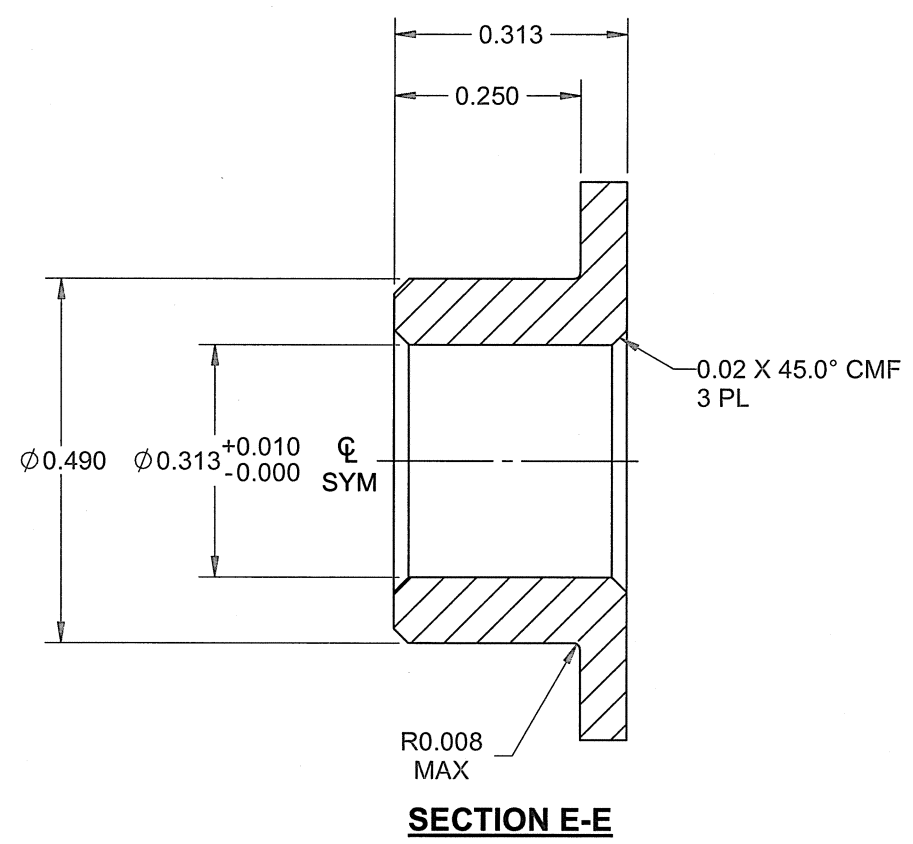
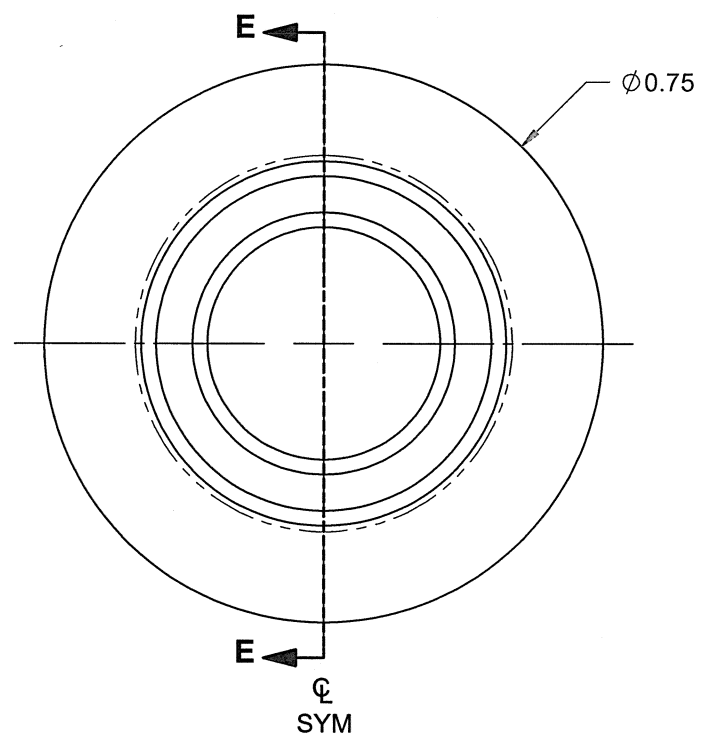
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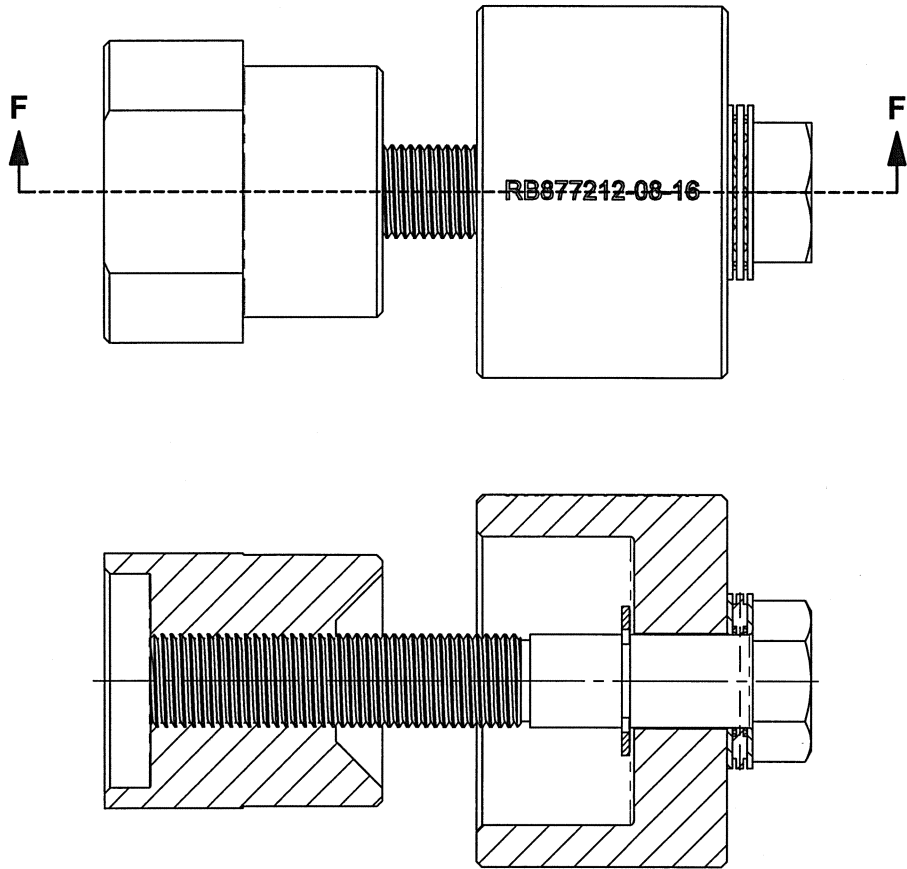


RB877212-08-9 SPRING GUIDE

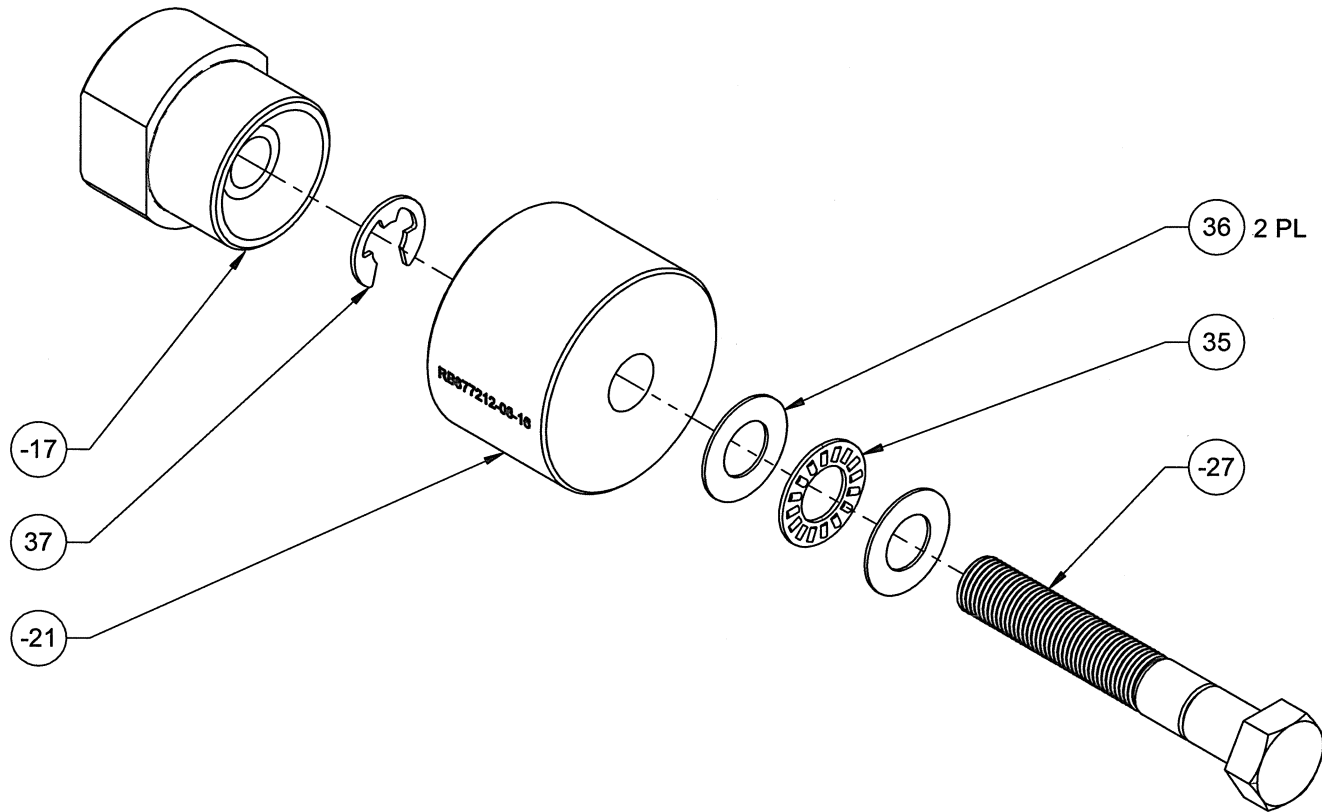
- NOTES:
- 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. D
MFG. APPR.	DP	RB877212-08	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DATE 3/21/2019		TAIL ROTOR BEARING CUTTER	NTS
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ITEM #	QTY	PART #	PART TITLE
-17	1	RB877212-08-17	R & I ADAPTER
-21	1	RB877212-08-21	CAP
-27	1	RB877212-08-27	BOLT
35	1	NTA-815	NEEDLE ROLLER THRUST BEARING 1/2" ID. X 15/16" OD. X 5/64" WD.
36	2	TRA-815	THRUST WASHER 5/16" ID. X 3/4" OD. X 0.03" WD.
37	1	McMaster#98407A138 OR EQUIV.	ZINC PLATED SPRING STEEL SIDE-MOUNT EXTERNAL RETAINING RING FOR GROOVE 0.396" OD. X 0.046" WD.



SECTION F-F



RB877212-08-16 BEARING REMOVAL & INSTALLATION TOOL ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. D
MFG. APPR.	DP	RB877212-08	SHEET 7 OF 11
APPROVED	W	TITLE	SCALE
DATE	3/21/2019	TAIL ROTOR BEARING CUTTER	NTS
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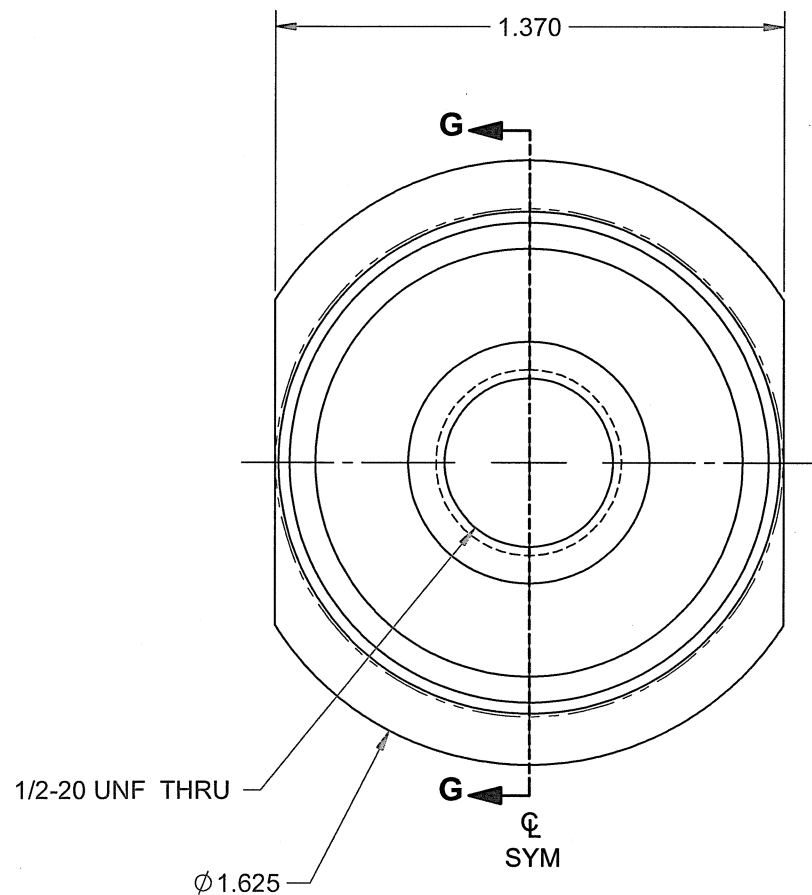
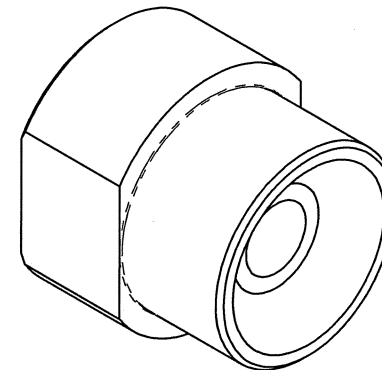
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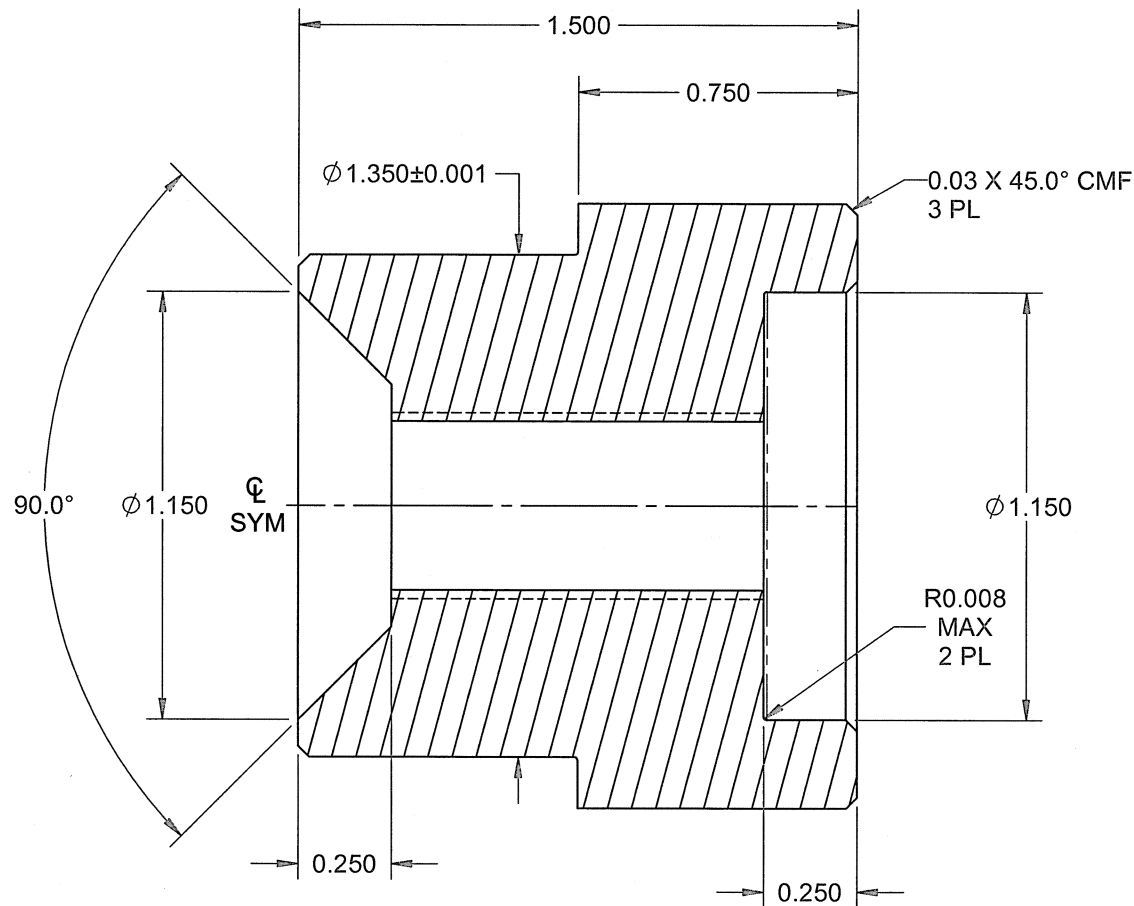
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RB877212-08-17 R & I ADAPTER



SECTION G-G

NOTES:

- 1) MATERIAL: 1144 STRESSPROOF
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. D
MFG. APPR.	DP	RB877212-08	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DATE	3/21/2019	TAIL ROTOR BEARING CUTTER	NTS
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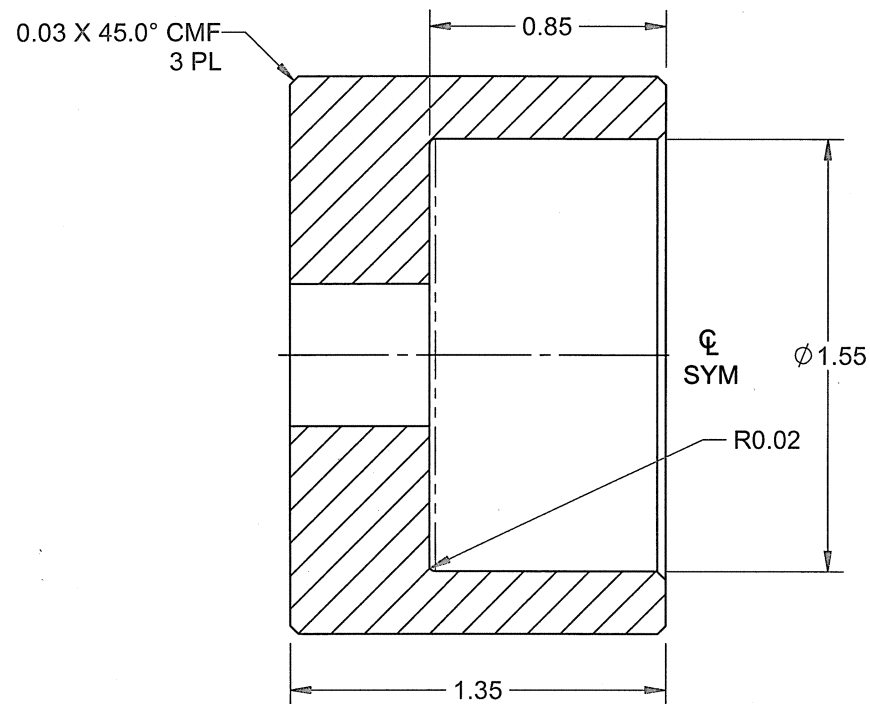
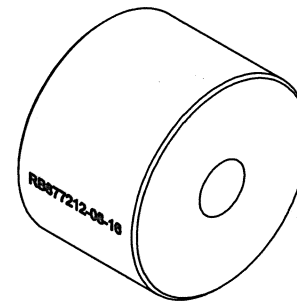
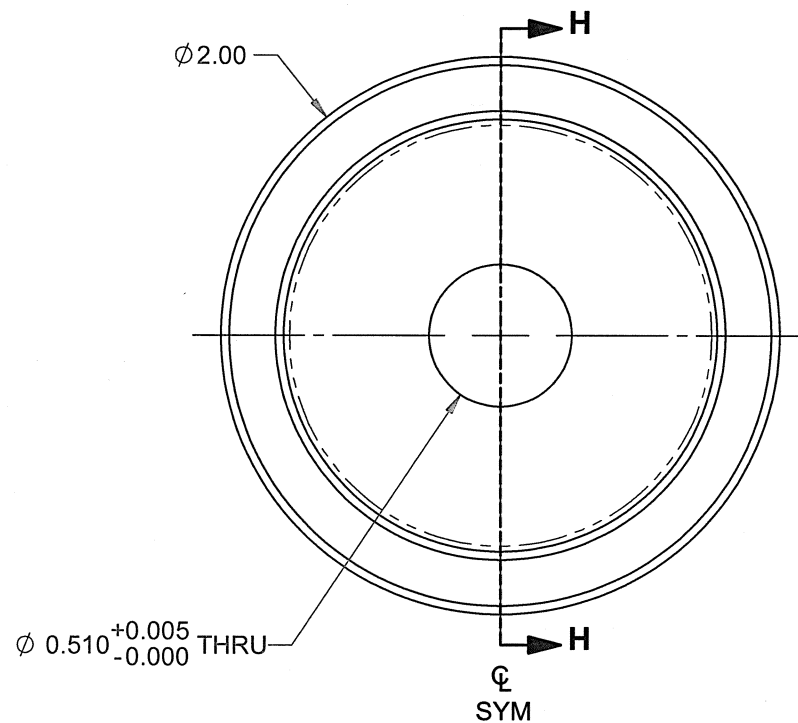
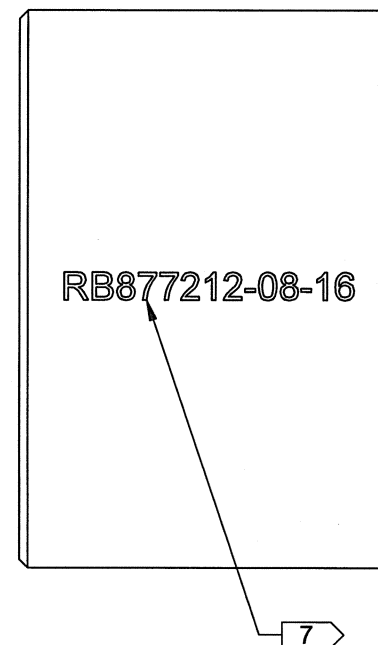
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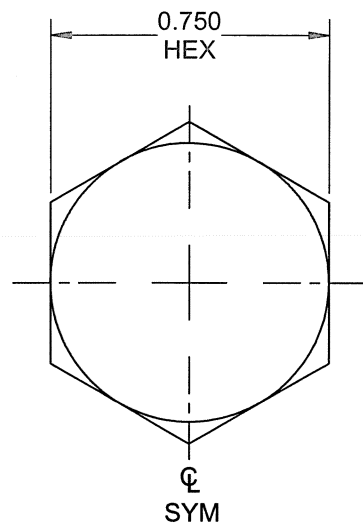
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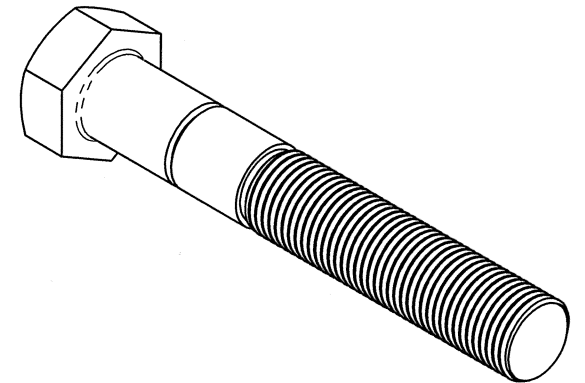
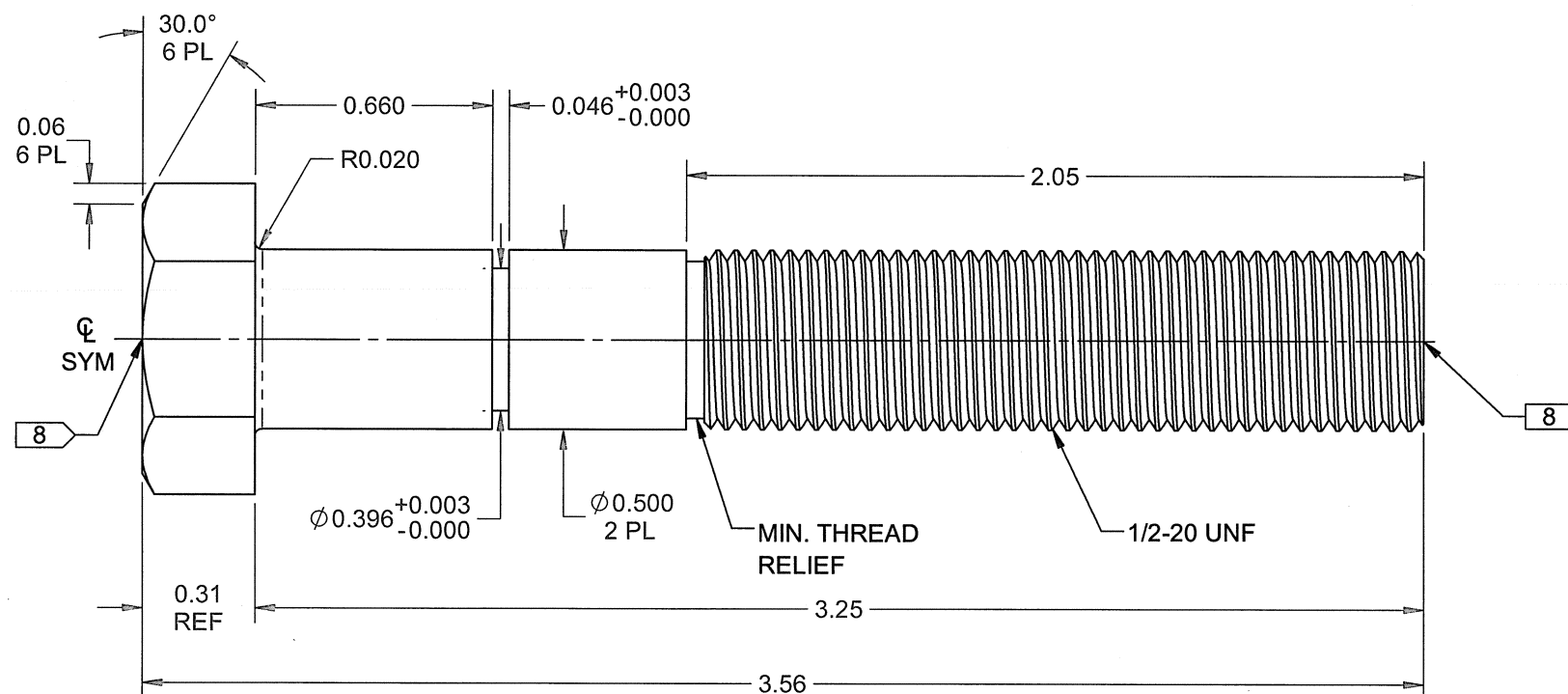
**SECTION H-H****RB877212-08-21 CAP****NOTES:**

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. D
MFG. APPR.	DP	RB877212-08	SHEET 9 OF 11
APPROVED	VIP	TITLE	SCALE
		TAIL ROTOR BEARING CUTTER	NTS
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RB877212-08-27 BOLT



NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. D
MFG. APPR.	DP	RB877212-08	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DATE	3/21/2019	TAIL ROTOR BEARING CUTTER	NTS
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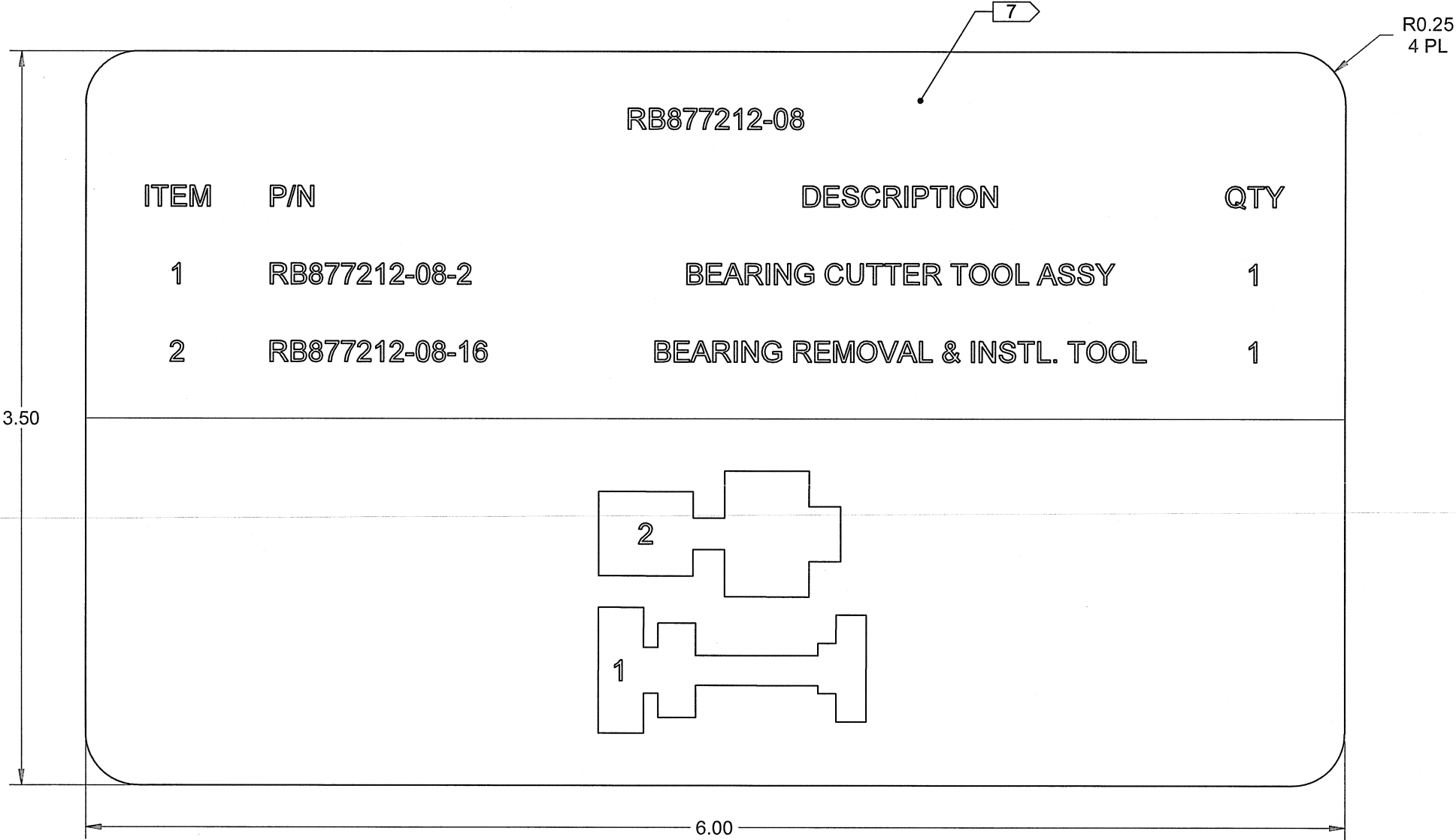
C

B

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RB877212-08-28 CONTENT PLACARD

8

- NOTES:
- 1) MATERIAL: JOHNSON PLASTICS #LM922402 OR EQUIV. (BLACK/WHITE MICROSURFACED IMPACT ACRYLIC 1/16" THK.)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) BLACK BACKGROUND WITH WHITE LETTERS AND LINES
 - 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RB877212-08-28 REV. D.DXF

DESIGN	MBB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MBB		
CHECKED	MBB	TOOL PART #	REV. D
MFG. APPR.	DP	RB877212-08	SHEET 11 OF 11
APPROVED		TITLE	SCALE
		TAIL ROTOR BEARING CUTTER	NTS
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